

Work Order ID 83022

83022

Page 1

April-12-12 12:31:13 PM

Item ID: D412-761-043

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Modified Latch Mechanism, LH

Stop ***NS2***

Start Date: 12/04/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 26/04/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/12 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI9580	A								
IIN D412-761	Rev D								

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D412-761-043 CHG001

Schulz

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

(4) 12/4/12 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83022

83022

Page 2

April-12-12 12:31:13 PM

Item ID: D412-761-043

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Modified Latch Mechanism, LH

Stop

NS2

Start Date: 12/04/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 26/04/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

130

0.00

130

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-761-043

Location:

PPP Rev:

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

44

4x

SP 12-04-13

12/4/17

12-04-14

MF
12-04-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-12-12 12:31:17 PM

Page 1

Work Order ID: 83022

83022

Parent Item: D412-761-043

D412-761-043

Parent Item Name: Modified Latch Mechanism, LH

Start Date: 12/04/2012

Required Date: 26/04/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 09-01-13 rev.C as per dwg DD verified by:EC IPP REV:B
11.11.29 AS PER DSI9580 DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3589-041		Manufactured	No			110	Each	0.0000	1	4			
-----------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

Sel *D3589-041*

LATCH ASSEMBLY

D3589-047		Manufactured	No			110	Each	4.0000	1	4			
-----------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

Sel *D3589-047*

FWD GUIDE

Location

Loc Qty

Loc Code

ST041

4

82609

4

D3589-049		Manufactured	No			110	Each	4.0000	1	4			
-----------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

Sel *D3589-049*

Aft Guide

Location

Loc Qty

Loc Code

ST041

4

82610

4

MS16997-24		Purchased	No			110	Each	34.0000	2	8			
------------	--	-----------	----	--	--	-----	------	---------	---	---	--	--	--

Sel *MS16997-24*

SCREW

Location

Loc Qty

Loc Code

ST333

34

119811

4

121321

30

119811 44
121321 42

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-12-12 12:31:17 PM

Page 2

Work Order ID: 83022

83022

Parent Item: D412-761-043

D412-761-043

Parent Item Name: Modified Latch Mechanism, LH

Start Date: 12/04/2012

Required Date: 26/04/2012

Start Qty: 4.00

Required Qty: 4.00

AN960JD6L

Purchased

No

110

Each

624.0000

2

8

**

*AN960JD6L *

Washer

Location

Loc Qty

Loc Code

ST337A

624

5519

624

110

Each

182.0000

2

8

**

MS21042L06

Purchased

No

*MS21042L06 *

Nut

Location

Loc Qty

Loc Code

ST300

182

118354

2

119109

1

119758

1

120360

178

120360

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-761 REV. D
INSTRUCTION FOR CONTINUED AIRWORTHINESS ICA-D412-761 REV. 1
AND INSTALLATION DRAWING D412-761-1 REV. D

REF. TCCA STC: SH09-4
REF EASA STC: 10028917

PURPOSE:

The purpose of this service instruction is to replace the MS16997-22 screw used in the latch assembly with MS16997-24 screw.

CHANGE:

5.0 PARTS LIST, FULL VERTICAL REFERENCE DOOR MOD (IIN-D412-761)
52.10 PARTS LIST (ICA-D412-761)

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	PART NUMBER	DESCRIPTION
X					D412-761-041	FULL VERTICAL REFERENCE DOOR KIT, LH
	X	1			D412-761-043	MODIFIED LATCH MECHANISM KIT, LH
1		X			D412-761-045	LARGE BUBBLE WINDOW KIT, LH
1			X		D412-761-047	DOOR MOUNTED INSTRUMENT PANEL KIT, LH
1				X	D412-761-049	ARMREST KIT, LH

IS:

	2				MS16997-24	SCREW
--	---	--	--	--	------------	-------

WAS:

	2				MS16997-22	SCREW
--	---	--	--	--	------------	-------

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO #01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 11.10.25
CERT. NO.: SH09-4
ISSUE NO.: 2

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83022
12/04/12

A	NEW ISSUE	XDF	11.10.25
REV.	DESCRIPTION	BY	DATE
DESIGN	XDF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	XDF		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9580	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		SCREW REPLACEMENT	NTS
DATE	11.10.25	COPYRIGHT © 2011 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

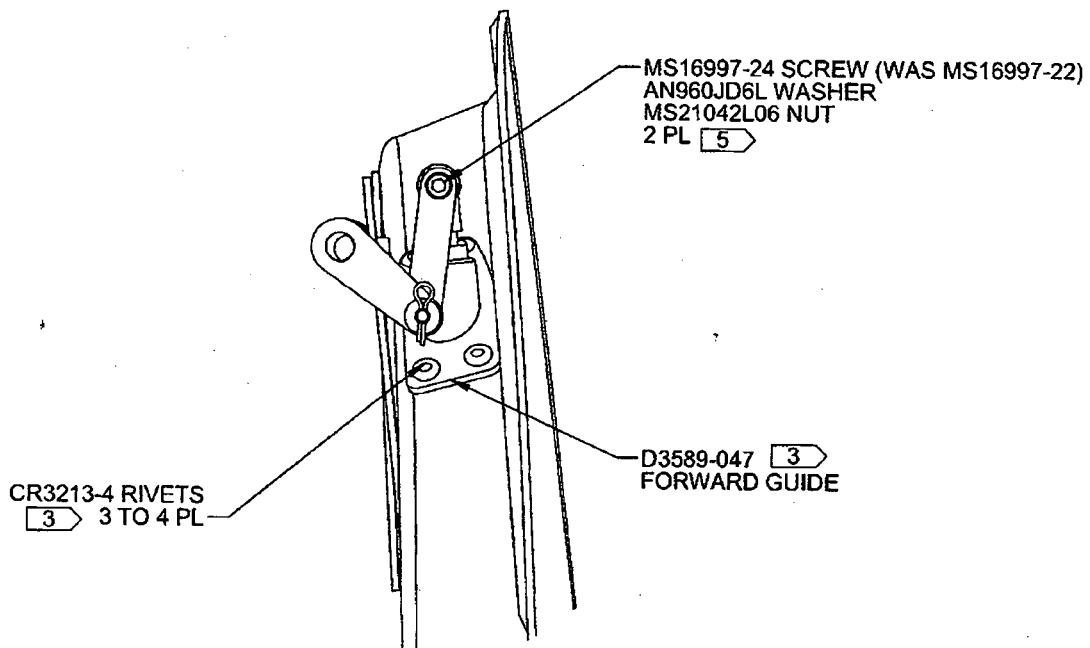
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



VIEW G
(FROM SHEET 7 OF INSTALLATION DRAWING D412-761-1)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 11.10.25
CERT. NO.: SH09-4
ISSUE NO.: 2

DESIGN	XDF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	XDF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9580	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SCREW REPLACEMENT	NTS
DATE	11.10.25	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

83022

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

DART AEROSPACE LTD.

IIN-D412-761

Page 8 of 11

5.0 PARTS LIST, FULL VERTICAL REFERENCE DOOR MOD

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	PART NUMBER	DESCRIPTION
X					D412-761-041	FULL VERTICAL REFERENCE DOOR KIT, LH
	X	1			D412-761-043	MODIFIED LATCH MECHANISM KIT, LH
1		X			D412-761-045	LARGE BUBBLE WINDOW KIT, LH
1			X		D412-761-047	DOOR MOUNTED INSTRUMENT PANEL KIT, LH
1				X	D412-761-049	ARMREST KIT, LH
	1				D3589-041	LATCH ASSEMBLY
	1				D3589-047	FORWARD GUIDE
	1				D3589-049	AFT GUIDE
	2				MS16997-22	SCREW
	2				AN960JD6L	WASHER
	2				MS21042L06	NUT
	1	1			D3676-1	LARGE BUBBLE WINDOW
	1	1			D3678-1	PLACARD
	1	1			D3678-3	PLACARD
	1	1			D3700-1	INBOARD WINDOW DOUBLER
	1	1			D3700-3	OUTBOARD WINDOW DOUBLER
	1	1			D3701-1	FLOOR DOUBLER
	1	1			D3702-1	FORWARD DOUBLER
	1	1			D3703-1	AFT DOUBLER
	1	1			D3703-3	AFT CORNER DOUBLER
	1	1			D3703-5	AFT CAP
	1	1			D3704-1	ESCUTCHEON
	1	1			D3704-3	ESCUTCHEON
	1	1			D3708-1	ANGLE
	1	1			D3708-3	ANGLE
	1	1			D3709-1	ANGLE
	1	1			D3709-3	ANGLE
	1	1			D3802-1-135	SEAL
	1	1			DT9458	CUTTING TEMPLATE
	26	1			AN3-7A	BOLT
	52	1			AN960JD10	WASHER
	26	1			MS21042L3	NUT
	1	1			MS24694-C5	SCREW (OR MS24694-S5)
	1	1			MS24694-C13	SCREW (OR MS24694-S13)
		1			D3705-041	INSTRUMENT PANEL ASSEMBLY
		1			D3705-043	* INSTRUMENT PANEL WELDMENT
		1			D3335-1	* SPRING
		1			D3705-5	* ACCESS PANEL
		1			D3706-5	* PIN
		2			D3707-3	* MOUNTING LUG
		4			AN526C1032R6	* SCREW
		1			AN960JD516	* WASHER
		1			MS171498	* SPRING SLOTTED PIN
		4			MS24693-C272	* SCREW (OR MS24693-S272)

*DENOTES PART IS INCLUDED WITH ASSEMBLY ABOVE

(CONTINUED ON PAGE 9)

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Revision: D

Date: 09.06.18

REFERENCE ONLY

DART AEROSPACE LTD.

IIN-D412-761

Page 9 of 11

(CONTINUED FROM PAGE 8)

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	PART NUMBER	DESCRIPTION
			2		D3707-1	MOUNTING LUG
			1		D3790-1	INDEXING BLOCK
			1		D3867-1	CONNECTOR PLATE
			4		AN3-3A	BOLT
			6		AN526C1032R6	SCREW
			2		AN743-12	BRACKET
			6		AN960JD10L	WASHER
			6		MS21075L3	NUTPLATE (OR MS21073-3)
			4		MS24693-C272	SCREW (OR MS24693-S272)
			1		MS27039-1-17	SCREW
			1		MS27039-1-27	SCREW
			4		MS21042L3	NUT
			2		MS21919WDG8	CLAMP
				1	D3694-041	MOUNTING PLATE ASSEMBLY
				1	D3694-1	* KEYWAY
				1	D3694-3	* PROTECTIVE PLATE
				1	D3694-5	* MOUNTING PLATE
				1	AN526C1032R8	* SCREW
				5	AN960JD10	* WASHER
				4	MS21042L3	* NUT
				2	MS21209F1-20	* HELI-COIL, SCREW LOCKING (RED)
				1	MS24693-C271	* SCREW (OR MS24693-S271)
				4	MS24693-C273	* SCREW (OR MS24693-S273)
				1	D3695-041	SLIDER ASSEMBLY
				1	D3695-1	* SLIDER
				1	D3695-3	* STOPPER
				1	D3801-1	* HAND RETRACTABLE SPRING PLUNGER
				1	MS21209F6-25	* HELI-COIL, SCREW LOCKING (RED)
				4	MS21209F1-20	* HELI-COIL, SCREW LOCKING (RED)
				4	MS24693-C276	* SCREW (OR MS24693-S276)
				1	D3780-041	ARMREST ASSEMBLY
				1	D3696-041	* ARM ASSEMBLY
				1	D3696-1	** ARM
				1	D3801-3	** HAND RETRACTABLE SPRING PLUNGER
				1	D3781-041	* LATERAL CUSHION ASSEMBLY
				1	D3781-043	* ARMREST CUSHION ASSEMBLY
				1	D3785-3	* BRACKET
				1	D3977-1	* BOLT
				1	D3978-1	* NUT (CASTELLATED)
				1	D3979-1	* WASHER (SQUARE HOLE)
				2	AN970-6	* WASHER
				1	MS24665-302	* COTTER PIN
				2	MS21042L3	* NUT
				2	MS24693-C272	* SCREW
				2	MS24693-C277	* SCREW
				1	NAS1149D0663J	* WASHER

* DENOTES PART IS INCLUDED WITH ASSEMBLY ABOVE

** DENOTES PART IS INCLUDED WITH ASSEMBLY ABOVE

(CONTINUED ON PAGE 10)

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Revision: D

Date: 09.06.18

(CONTINUED FROM PAGE 9)

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	PART NUMBER	DESCRIPTION
				11	AN3-6A	BOLT
				1	AN6-26	BOLT
				1	AN310-6	CASTELLATED NUT
				11	AN960JD10	WASHER
				1	AN960JD616L	WASHER
				2	NAS1515H6L	WASHER
				1	MS24665-302	COTTER PIN
				3	MS21071L3	ANCHORNUT
				8	MS21075L3	NUTPLATE

6.0 PARTS LIST, OPTIONAL VENT KIT

QTY -141	PART NUMBER	DESCRIPTION
X	D412-761-141	VENT KIT
4	D3932-1	SNAP VENT

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-761 REV. D
INSTRUCTION FOR CONTINUED AIRWORTHINESS ICA-D412-761 REV. 1
AND INSTALLATION DRAWING D412-761-1 REV. D

REF. TCCA STC: SH09-4
REF EASA STC: 10028917

REFERENCE

PURPOSE:

The purpose of this service instruction is to replace the MS16997-22 screw used in the latch assembly with MS16997-24 screw.

CHANGE:

5.0 PARTS LIST, FULL VERTICAL REFERENCE DOOR MOD (IIN-D412-761)
52.10 PARTS LIST (ICA-D412-761)

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	PART NUMBER	DESCRIPTION
X					D412-761-041	FULL VERTICAL REFERENCE DOOR KIT, LH
	X	1			D412-761-043	MODIFIED LATCH MECHANISM KIT, LH
1		X			D412-761-045	LARGE BUBBLE WINDOW KIT, LH
1			X		D412-761-047	DOOR MOUNTED INSTRUMENT PANEL KIT, LH
1				X	D412-761-049	ARMREST KIT, LH

IS:

	2				MS16997-24	SCREW
--	---	--	--	--	------------	-------

WAS:

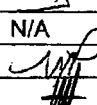
	2				MS16997-22	SCREW
--	---	--	--	--	------------	-------

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE #02)

DATE: 11.10.25
CERT. NO.: SH09-4
ISSUE NO.: 2

A	NEW ISSUE	XDF	11.10.25
REV.	DESCRIPTION	BY	DATE
DESIGN	XDF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	XDF		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9580	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		SCREW REPLACEMENT	NTS
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